

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008292**Date Inspected:** 29-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This QA Inspector observed the following work in progress: FCAW welding of deck panel diaphragm to floor beam weld joint SSD18A-PP022-004 located on OBG Segment 3AE. ZPMC welders were identified as 051356 and 044795. ZPMC QC was identified as Li Jia. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G (2F)-Repair-2.

Bay 2-

This QA inspector performed Ultrasonic Testing (UT) of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG Floor beam components. The weld identification numbers are as follows: FB009-032-043. FB011-028-045 (R1), FB011-033-043 (R1), FB011-031-045 (R1) and FB009-031-045 (R1).

SAW welding of weld joint 026 located on Floor Beam FB3038-001. ZPMC welder was identified as 207237. ZPMC QC was identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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## WELDING INSPECTION REPORT

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Bay 3-

This QA inspector performed Ultrasonic Testing (UT) of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members were identified as OBG Floor beam components. The weld identification numbers are as follows: FB003-181-032, 044, SSD19A-PP097-132, SSD18-PP106-006, FB003-187-008, 020 and FB023-011-148.

SMAW welding of weld joint CB202G-025-050 located on OBG cross beam 10. ZPMC welder was identified as 058102. ZPMC QC was identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2212-B-U3b.

FCAW welding of weld joint CB202A-010-002 located on OBG cross beam 10. ZPMC welder was identified as 044790. ZPMC QC was identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation occurred between QA and QC this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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